

Work Order ID 60178

Monday, June 28, 2010 1:30:24 PM

Page 1

Item ID: D3836-041

Accept

Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 6/28/2010 Start Qty: 2.00

Required Date: 7/2/2010 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup

Start

Stop

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3836

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-1 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: 111679

6- grind weld flush where indicated on dwg

130

QC9- Insp visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

②

Pl 10.07.08

SAD 10-07-07

②

10.07.09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60178

Monday, June 28, 2010 1:30:24 PM



Page 2

Item ID: D3836-041

Accept



Setup

Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 6/28/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 2.00



Customer:

Reference:

Run

Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

QC5- Inspect part completeness to step on W/O

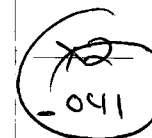
0.00

Quality Control

Memo

0.00

5/10/07/09



150



Packaging

Identify as per dwg & Stock Location:

B/C

0.00

Packaging

Memo

0.00

B/C 10.07.08

160



QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

10-7-9

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Picklist Print

Monday, June 28, 2010 1:30:28 PM

Page 1

Work Order ID: 60178

Parent Item: D3836-041

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 6/28/2010

Required Date: 7/2/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3

Manufactured

No

100

Each

11.0000

1

2



Spacer Bushing

Location

Loc Qty

Loc Code

WA

11

58406

1

58974

10

M304TS0.750W.065

Purchased

No

100

f

617.4786

1.7808

3.749053



304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT

1.4628

112398

0

114482

1.4628

WA

616.015785

114520

616.015785

357780 → (2)

SAD

10-07-08

3.7491

PL 10-07-08

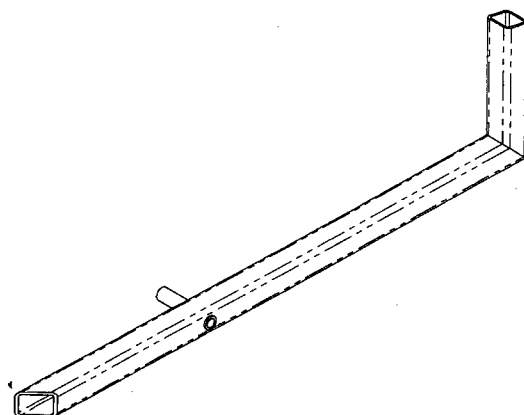
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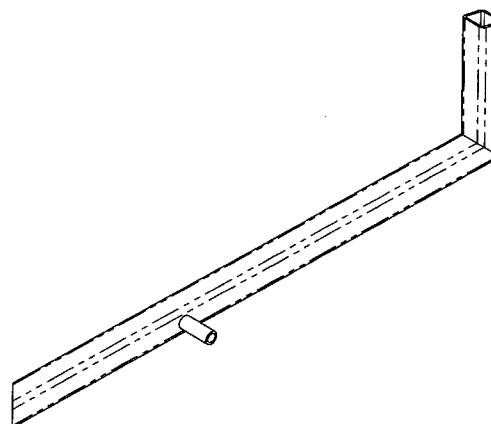
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NOTE: Date & initial all entries



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs EACH
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60178

Ed 10-6-28

RELEASED
Ed 10-6-28

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3836

REV. A
SHEET 1 OF 3

TITLE
RIB ASSY (BASKET LID)

SCALE
NTS

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Dart Aerospace Ltd

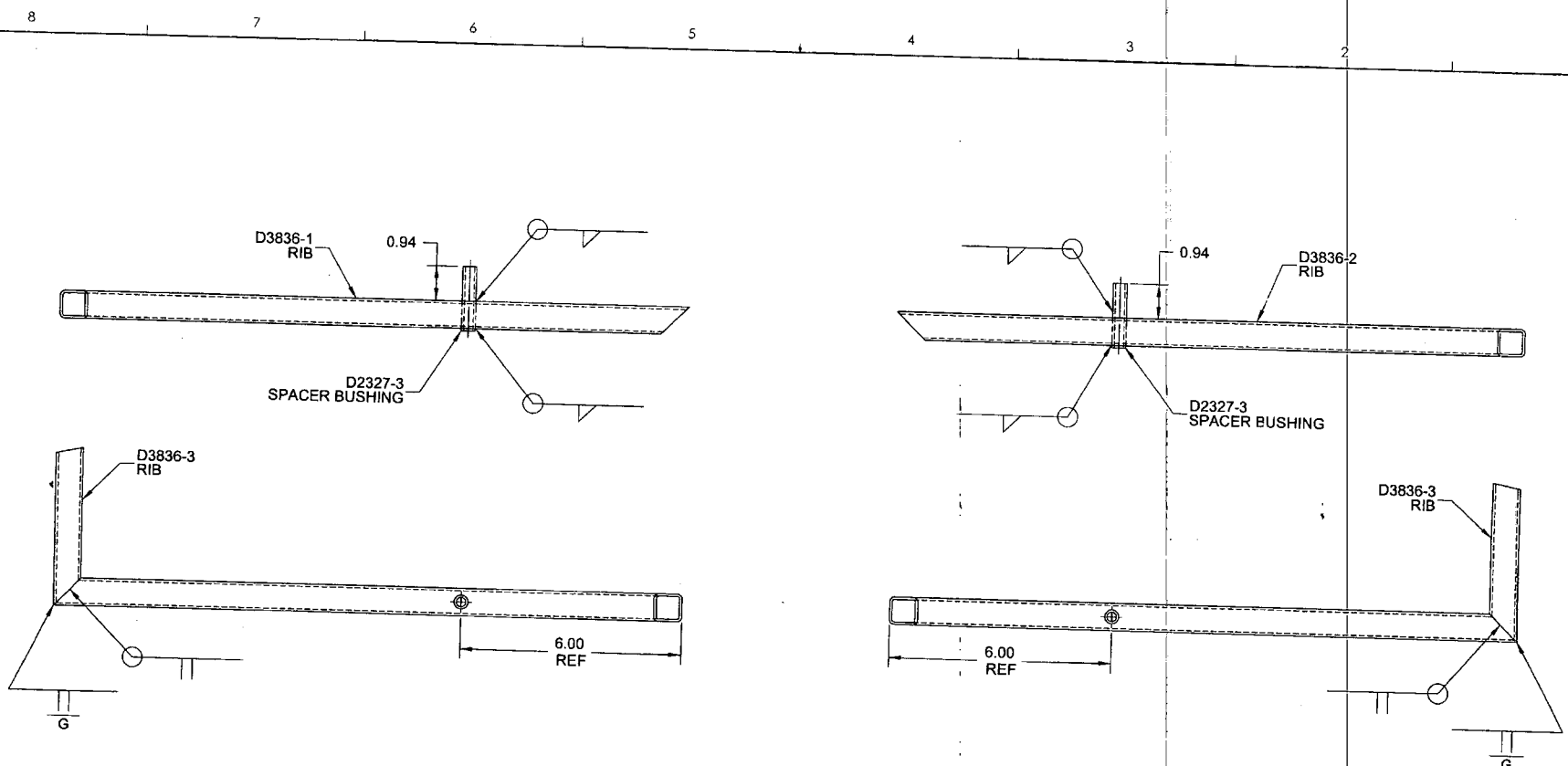
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D3836-041 RIB ASSY (BASKET LID, LH)

D3836-042 RIB ASSY (BASKET LID, RH)

who 60178

RELEASED
08/11/81

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3836 TITLE RIB ASSY (BASKET LID) DATE 08.09.24	REV. A
DRAWN			SHEET 2 OF 3
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
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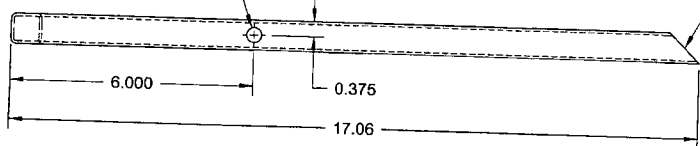
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0.75 X 45°
CHAMFER



$\varnothing 0.375^{+0.020}_{-0.000}$ THRU



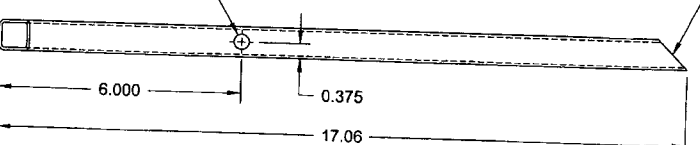
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CHAMFER

D3836-1 RIB

0.75 X 45°
CHAMFER

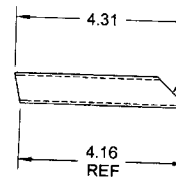


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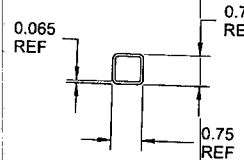


0.75 X 45°
CHAMFER

D3836-2 RIB



D3836-3 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

wls 60125

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3836-2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3836	REV. A
MFG. APPR.		TITLE RIB ASSY (BASKET LID)	SHEET 3 OF 3
APPROVED		SCALE NTS	
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